

Friday, February 13, 2015 10:52:15 AM

1 29528

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Gasket 9.01

Stop *NS2*

Start Date: 2/13/2015 **Start Qty:** 5.00

5

Cust Item ID:

Required Date: 2/13/2015 **Req'd Qty:** 5.00

5

Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-02-13 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3245	D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3245

Dwg Rev: D

Prog Rev: D

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

⑤ _____ Dec 15/02/22

5 _____ DL 15/02/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Unapproved									

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Picklist Print

Friday, February 13, 2015 10:52:18 AM

Page 1

Work Order ID: 129528

129528

Parent Item: D3245-11

D3245-11

Parent Item Name: Gasket 9.01

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B04.12.06Made in-houseKJ/JLM
IPP Rev:C ecn 1052/water jet 07-11-05 DD verified :EC IPP Rev:C
12.11.07 PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89		Purchased		No		100	sf	0.0000	0.0438	1			
G89									**				
Coated Cloth													

7638

DC 15/02/21

D-3245

94714

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

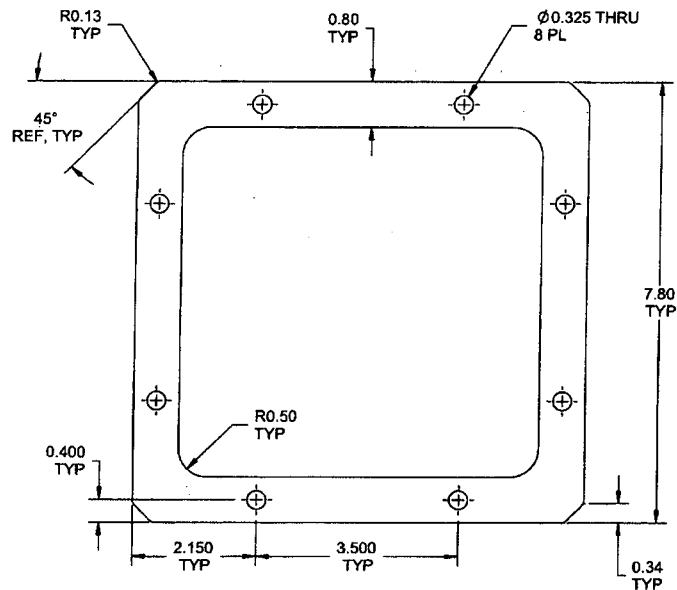
Work Order update only ☐

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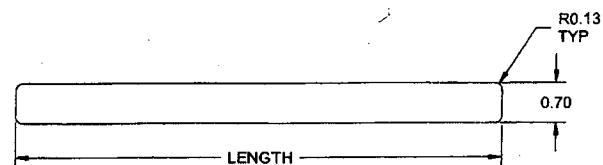
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

STANDARD
K. J. B. O.
UNCONFIDENTIAL COPY
NO. 129528 MLJ
1502-13

RELEASED
2012-11-06
JMP

- NOTES:**
- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.080 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/-11/-13 = LESS THAN 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3245
MFG. APPR.		REV. D
APPROVED		SHEET 7 OF 7
DE APPR.		TITLE
DATE	12.10.16	ACCESS PANEL ASSY
		SCALE
		NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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